

Work Order ID 83471

April-18-12 2:39:54 PM

83471

Page 1

Item ID: D4079-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Clamp Half, Attachment

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4079	B								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 2.750" long

PO/MLJ 12/05/05

12 0

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA931

Folio rev: AA

Dwg Rev: 6

PO/MLJ 12/05/06

12 0

Deburr

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4079-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp Half, Attachment
 Start Date: 18/04/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/05/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

out PO

12/05/06

12

✓

SA

12/5/9

12

✓

(12)

MG

12-5-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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83471

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 18/04/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 02/05/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D4079-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Clamp Half, Attachment

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/05/09

ME

12-05-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 83471

83471

Parent Item: D4079-1

D4079-1

Parent Item Name: Clamp Half, Attachment

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	18.1670	0.23	2.905263			

M6061T6B2 000X02 000

6061-T6 Bar 2.00 x 2.00

**

PO 12/05/05

Location

Loc Qty

Loc Code

MAT009

18.167



113123

4.977

119801

12

13085

1.19

3.0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83471
Description: Clamp Half, Attachment		Part Number:	D4079-1
Inspection Dwg: D4079 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/-0.010	2.501	✓		VERN	PHD-01
Ø0.203	+0.005/-0.001	0.204	✓		"	"
0.75	+/-0.030	0.743	✓		"	"
0.375	+/-0.010	0.369	✓		"	"
0.310	+/-0.010	0.310	✓		"	"
1.882	+/-0.010	1.882	✓		"	"
0.78	+/-0.030	0.777	✓		"	"
R0.13	+/-0.030	0.125	✓		Rad gauge	
1.440	+/-0.010	1.440	✓		VERN	PHD-01
R0.38	+0.010/-0.000	0.380	✓		Rad gauge	
R0.050	+/-0.010	R 0.050	✓		Rad gauge	
R0.73	+/-0.030	R 0.720	✓		VERN	PHD-01
Ø0.257	+0.006/-0.001	0.259	✓		"	"
R0.25	+/-0.030	0.250	✓		Rad gauge	
0.390	+/-0.010	0.384	✓		VERN	PHD-01
0.850	+/-0.010	0.852	✓		"	"
0.025 x 45°	+/-0.010 x 0.5°	0.025 x 45°	✓		"	"
0.100	+/-0.010	0.100	✓		"	"
R0.05	+/-0.030	0.062	✓		Rad gauge	
1.240	+/-0.010	1.240	✓		VERN	PHD-01
1.65	+/-0.030	1.650	✓		"	"
0.60	+/-0.030	0.605	✓		MIC Depth	PHD-09
0.23	+/-0.030	0.220	✓		VERN	PHD-01
0.025	+/-0.010					

Measured by: POKX	Audited by: [Signature]	Preliminary Approval:
Date: 12/05/06	Date: 12/5/9	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	[Signature]

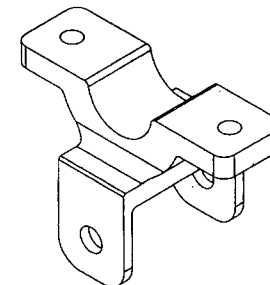
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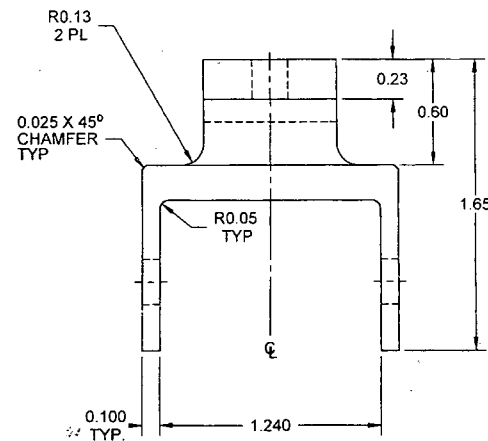
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WITHOUT NOTICE
WORK ORDER

WORK ORDER
NO. 83471 M65
12/04/10



RELEASED
2010-09-07
NMP

7) WEIGHT: 0.09 lbs

B	R0.38 WAS R0.48.	VB	10.07.30
A	NEW ISSUE	VB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN	VB	DART AEROSPACE LTD	
DRAWN	VB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VB	DRAWING NO.	REV. 1
MFG. APPR.	VB	D4079	SHEET 1 OF
APPROVED	VB	TITLE	SCALE
DE APPR.	VB	CLAMP HALF, ATTACHMENT	NT
DATE	10.07.30	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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